Work Order ID 124586 *124586* Page 1 Tuesday, September 16, 2014 10:26:51 AM Accept *N900040100* Setup Item ID: D3575-5 Start **Revision ID:** Stop Cargo Floor Protector **Item Name:** *1* Start Oty: 1.00 9/17/14 **Cust Item ID: Start Date:** Req'd Qty: 1.00 Required Date: 9/18/14 *1* **Customer:** Reference:

Date: 14-9-16 Tooling: Date: Approvals: **Process Plan:** Stop SPC (Y/N): Date: QC: Date: Reject Reject Tool # Plan Insp. Set Up/ **Tool ID** Accept Sequence ID/ Operation Number Stamp Code Qty Qty **Work Center ID Description Run Hours Revision Nbr Draw Nbr** D3575 Rev A 100 0.00

FLOW WATER JET *100* 0.00 Waterjet Memo

0.00

1-Cut as per Dwg D3575 Dwg Rev: Prog Rev: FLOW CNC Waterjet

Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB 0.00

110 0.00 QC Memo

Quality Control

0.00 QC8- Inspect parts - second check

120 QC Memo Quality Control

110

120

Start Run

De 14/09

DQA:		Date:										
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			_	AEROSPACE
QA Closed:		Date:						· · · · · · · · · · · · · · · · · · ·	W	ork Order up	odate only	
Work Orde	er:				DISPOSITION			AGAINST	DE	PARTMENT,	/PROCESS	
				—	Rework	1		Skid-tube Crosstube		1	Water Jet	Engineering
Part N	io.				Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	Quality
	-			_	Use-as-is		I	noforming Finishing	4	Rec/Store/Packaging Othe		
NCR N	lo				Suspected Unapproved			Large Fab Composite	$\overline{}$]	Supplier	
Doot	<u> </u>		T T	D	·:			A		C: 0	<u> </u>	
Root Cause	Date	Step	Oty	Desci	ription of work order update or non-conformance	1	Initial	Action		Sign & Date	Verification	QC Inspector
Design	Date	3teh	Qty		or non-comormance	Ci	nief Eng	Description		Date	Verification	QC IIIspector
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	Bendin	g			Bend		Folio/F	Program	_	Outside Dim	ensions	Pressure/Forced
	Centre	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	⊢ -	Temperature/Cure
	Crimp/Kink/Ripple/Wave			<u> </u>	Burrs		Inspect	ion Incomplete/Unqualified	L	Part Lost/Mi	issing	Weld
	Cuffs			<u> </u>	Contamination	<u></u>	4	tions Incomplete/Unclear	L	Part Moved		Wrong Stock Pulled
	Crushing			<u> </u>	Countersink	L	1 '	gned/off center	L	Positioned V	_	- 7
	Heat Treat			<u> </u>	Cut Too Short	<u></u>	Mislabe			Power Loss/	Surge	Other
	Inspection Strip in Tube				Drawing	<u></u>	Misrea					
		'Chatter			Drill Holes	L	Off-set					
	Turning Sequence				Finish		-i	Calibration			- · · · · · · · · · · · · · · · · · · ·	
	Wave/Twist in Tube			- 1	Fit/Function	1	Out of	Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

124586 Page 2 Tuesday, September 16, 2014 10:26:51 AM Accept *N900040100* D3575-5 Setup Start Item ID: **Revision ID:** Cargo Floor Protector Item Name: *1* Start Qty: 1.00 **Start Date:** 9/17/14 **Cust Item ID:** Required Date: 9/18/14 **Req'd Qty:** 1.00 *1* **Customer:** Reference: Run **Tooling:** Process Plan: Date: Date: Approvals: Stop Date: SPC (Y/N): QC: Date: Reject Reject **Tool ID** Tool # Plan Accept Insp. Sequence ID/ **Operation** Set Up/ Stamp Number Qty Work Center ID Code Qty **Description Run Hours** 0.00 130 Small Fab *120* 0.00 Small Fab Deburr if necessary. Small Fab 140 QC5- Inspect part completeness to step on W/O *140* 0.00 OC Memo Quality Control Identify as per dwg & Stock Location: 0.00 150 14/7/18 (1)/ *150*

Packaging

Packaging

Memo

0.00

DQA:		Date	:										\sim \sim \sim \sim \sim	DT
QA Closed:		Date	:		WORK ORDER NON	-C(ONFOI	RMANCE /	UPDATE	W	ork Order up	odate only	A E	ROSPACE
· •					DISPOSITION				AGAINST		PARTMENT			
Work Orde	er:					1		s			1)4/-4 L-4	–	
Part N	lo.				Rework	-	i .	Skid-tube	Crosstube	-	Dro	Water Jet	Engine	· —
raitiv	····				Scrap Use-as-is	1	l	Machining noforming	Small Fab Finishing	-	4	d. Eng. Coor. re/Packaging	 i	lality Other
NCR N	No				Suspected Unapproved		mem	Large Fab	Composite	-	Supplier			,tile!
Root				Desc	l ription of work order update		I Initial	А	action		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Des	scription		Date	Verification	QC In	spector
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Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup														
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	Bendin	_			Bend		1	rogram		_	Outside Dim	├	Pressure/I	Forced
	_	Not Conce	entric		BOM/Route		Grain			_	Over/Under	tolerance	Set-up	
	Cracks				Broken/Damage/Defect	\perp	Hardwa				Part Incorre	⊢	Temperati	ure/Cure
	—	Kink/Rippl	e/Wave	<u> </u>	Burrs	<u>_</u>	1	ion Incomplete/	•	<u> </u>	Part Lost/Mi	- <u>-</u>	Weld	
	Cuffs				Contamination	<u>_</u>	4	ions Incomplete		_	Part Moved		Wrong Sto	ock Pulled
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		tion Strip in	า Tube		Drawing	<u></u>	Misread	t						
ļ		'Chatter			Drill Holes		Off-set							
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	Wave/Twist in Tube				Fit/Function	1	Dut of 9	Seguence						

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Work Orde Tuesday, Septem		24586 4 10:26:51 AM				Page	e 3						
Item ID: Revision ID: Item Name:	D3575-5 Cargo Floor	Protector		Accept	*N900	ი4ი	100)* s	•	Start Stop		S1*	
Start Date: 9/17/14 Star		Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:				, i d				
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		ate:		F	Run	Start Stop		R1* R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
*160 *160*		QC21- Final Inspection	Work Order Release	0.00				M	(<u>7</u>		109-1	<u> </u>	_

Quality Control

H14-9-18

DQA:		_ Date:)T
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / L		Work O	rder ut	odate only	AEROSP	ACE
		·			DISPOSITION				AGAINST I			<u> </u>		
Work Orde	er:					,			. г					_
D N	1				Rework			Skid-tube	Crosstube		_	Water Jet	Engineering	_
Part N	10				Scrap			Machining	Small Fab	┦ 、		d. Eng. Coor.	Quality	_
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NCR N	10.				Suspected Unapproved	j		Large Fab	Composite [Supplier_		
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Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Des	cription		Date	Verification	QC Inspect	or
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	Bendin	3			Bend		Folio/F	Program		Outs	ide Dim	iensions	Pressure/Forced	ł
	Centre	Not Conce	ntric		BOM/Route		Grain			Over	r/Under	tolerance	Set-up	
	Cracks				Broken/Damage/Defect		Hardwa	are		Part	Incorre	ct	Temperature/Cu	ure
	Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/l	Unqualified	Part	Lost/Mi	issing	Weld	
	Cuffs				Contamination		Instruct	tions Incomplete,	/Unclear	Part	Moved		Wrong Stock Pu	lled
	Crushing				Countersink		Misali	gned/off center		Posit	tioned V	Vrong		
	Heat Treat				Cut Too Short		Mislabe	eled		Pow	er Loss/	Surge	Other	
	Inspection Strip in Tube				Drawing		Misrea	d	_					
	Marks/Chatter				Drill Holes		Off-set							
	Turning Sequence				Finish		Out of	Calibration						
	Wave/Twist in Tube				Fit/Function	1	Out of	Sequence						

Picklist Print

Tuesday, September 16, 2014 10:26:55 AM

Work Order ID: 124586

124586

Parent Item:

D3575-5

D3575-5

Parent Item Name:

Cargo Floor Protector

Start Date: 9/17/14

Required Date: 9/18/14

Date

Issued

Page 1

Status

Start Qty: 1.00

**

Required Qty: 1.00

Comments:

IPP Rev: A New Issue 07.07.23

verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued]
MLEXS.125-F60029-04		Purchased	No			100	sf	6,128.116	10.666	12		

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

Location		Loc Oty	Loc Code	
MAT019		4381.525		
12	4866	106		
m?	126425	160.925		
mj	127934	690.6		
fn	12874	864		11.6
m	130209	2560		
TPI		1746.59178		
m:	129759	1746.59178		

DQA:		_ Date:										™ AÄ DT
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:		Date:							W	ork Order up	odate only	
Work Orde	or.				DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
WOIN OTG					Rework			Skid-tube Crosstube		1	Water Jet	Engineering
Part N	lo.				Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	Quality
					Use-as-is			noforming Finishing	-	Rec/Sto	Other	
NCR N	10				Suspected Unapproved			Large Fab Composite	-]	Supplier	
Root				Desci	ription of work order update	1	nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material												
Operator												
Offset/Setup	_											
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Landir 1	ng Gear				General		1 .		_	7	_	 1
1	Bending			ļ	Bend		1	Program	<u></u>	Outside Dim	<u> -</u>	Pressure/Forced
		lot Conce	ntric		BOM/Route		Grain		_	Over/Under	-	Set-up
	Cracks			<u> </u>	Broken/Damage/Defect	_	Hardwa		_	Part Incorre		Temperature/Cure
	Crimp/Kink/Ripple/Wave			<u> </u>	Burrs		1	ion Incomplete/Unqualified	_	Part Lost/Mi	issing	Weld
	Cuffs			_	Contamination		1	tions Incomplete/Unclear		Part Moved	L	Wrong Stock Pulled
	Crushing				Countersink		1 7	gned/off center		Positioned V		
	Heat Treat			<u> </u>	Cut Too Short	<u> </u>	Mislabe			Power Loss/	Surge	Other
	Inspection Strip in Tube			<u> </u>	Drawing	<u> </u>	Misread					 .
	Marks/Chatter				Drill Holes		Off-set				<u>_</u> <u>_</u>	
	Turning Sequence				Finish		4	Calibration				
	Wave/Twist in Tube				Fit/Function		Out of !	Sequence				

DART AEROSPACE LTD	Work Order: 124586	
Description: Cabin Floor Protector	Part Number: D3575-5	_
Inspection Dwg: D3575 Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolcrance	Dimension	Accept	Heject	Inspection	Comments
Ø3.00	+0.006/-0.001	2.99				
3.38	+/-0.030	3.36				
6.50	+/-0.030	6.50				
26.13	+/-0.030	26.13			:	
30.13	+/-0.030	30.13				
2.00	+/-0.030	2.0-				
3.50	+/-0.030	3,50		1		
14.25	+/-0.030	14.25				
25.13	+/-0.030	25.13				
29.38	+/-0.030	29.34				
30.38	+/-0.030	3038		:		
31.50	+/-0.030	31.50				
1.00	+/-0.030	1,e~				
4.38	+/-0.030	4,35				
14.50	+/-0.030	14.50				
16.00	+/-0.030	16.60				
23.13	+/-0.030	23.13				
26.88	+/-0.030	26.80			,	
27.69	+/-0.030	71.69				
1.00	+/-0.030	1.00				
3.75	+/-0.030	7.75	+ • • • • • • • • • • • • • • • • • • •			
9.63	+/-0.030	9,63				
16.13	+/-0.030	16.13				
28.06	+/-0.030	28.06				
32.15	+/-0.080	32.15	DAS			

Measured by: Audited by: 27 | Prototype Approval: N/A

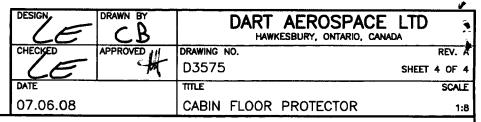
Date: 14/09/17 Date: N/A

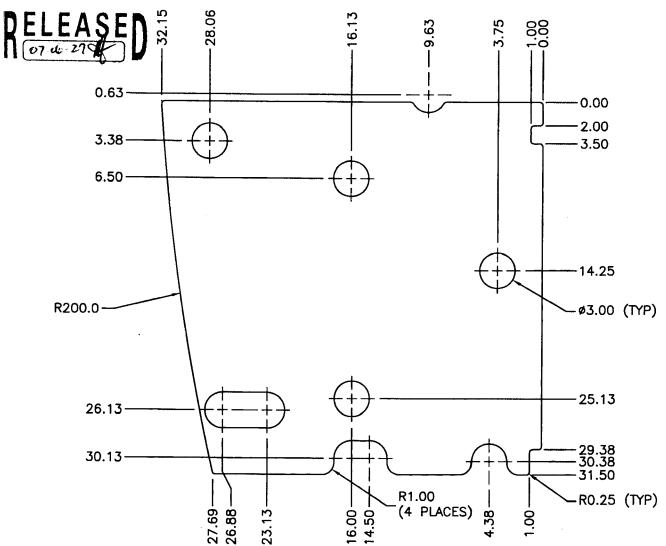
Rev	Date	Change	Revised by,	Approved
Α	08.01.16	New Issue	KJ//DD	78
	···		• ()	•

DQA:		. Date:			WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPACE	
Work Orde					DISPOSITION			AGAI	NST DE	PARTMENT	/PROCESS		
Work Orde	·				Rework			Skid-tube Crosst	ا موں	1	Water Jet		
Part N	0				Scrap			Machining Small	Fab	Pro	Engineering Quality		
NCR N	0				Use-as-is Suspected Unapproved		Therr	noforming Finisl Large Fab Compo		Rec/Stor	e/Packaging Supplier	Other	
Root				Desci	ription of work order update	١	nitial	Action		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material		İ											
Operator													
Offset/Setup													
Process													
Supplier	7				•								
Training								·					
Transport			İ										
Unapproved													
						FAI	ULT CA	TEGORY					
Landir	ng Gear				General		_			_			
	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced	
	Centre No	ot Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	it [Temperature/Cure	
[Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld	
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled	
	Crushing				Countersink		Misalig	gned/off center		Positioned W	/rong _		
					Cut Too Short		Mislabe	eled		Power Loss/:	Surge	Other	
[Inspectio	n Strip in	Tube		Drawing		Misread	d					
ĺ	Marks/Ch	natter			Drill Holes		Off-set						
	Turning S	equence	!		Finish	Out of Calibration							
	Wave/Twist in Tube				Fit/Function		Out of :	Sequence					

H./FORMS/Quality Assurance\approved QA/NCRWO RevH







D3575-5 CABIN FLOOR PROTECTOR (SHOWN) D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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